



Dart Aerospace Ltd.
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D2876

Job Sheet 185955



Part No: D2876

Job Qty: 30 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B Esr Rev:B 00.05.19 Added inspect level 8 EC IPP Rev:C Now M6061-T6 06-06-23 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	30 pcs		11/28/18	0.00	0.67	Waterjet - Flow		11/28/18
120	QC	30 pcs		11/28/18	0.00	0.00	QC8		38
140	HandFinish	30 pcs		11/28/18	0.00	0.30	HandFinish1		DR 18/11/2018
150	QC	30 pcs		11/28/18	0.00	0.00	QC7-1		DEC 05 2018
160	Packaging	30 pcs		11/28/18	0.00	0.00	Packaging3	57013	DEC 06 2018
170	QC21-SA	30 Ea		11/28/18	0.00	0.00	QC21		DEC 06 2018

Part Op
Descriptions: 100 - 1-Cut as per Dwg D2876

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.100	6061-T6 .100 Sheet	1.5480 sf (.0516 ea)	100-Waterjet - Flow - 1	5025678

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.100	2	41	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.980Inches $\pm$ 0.030	1.010 0.950		
2	Saddle Spacer	1.000Inches $\pm$ 0.030	1.030 0.970		
3	Saddle Spacer	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
4	Saddle Spacer	3.360Inches $\pm$ 0.030	3.390 3.330		
5	Saddle Spacer	2.480Inches $\pm$ 0.030	2.510 2.450		
6	Saddle Spacer	0.555Inches $\pm$ 0.010	0.565 0.545		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



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Container No: S128759



Part: D2876

Job No: 185955

Serial No/Batch: S128759

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/18/18

